

TABLE OF CONTENTS

CHAPTER	TITLE	PAGE
	DECLARATION	ii
	DEDICATION	iii
	ACKNOWLEDGEMENTS	iv
	ABSTRACT	v
	ABSTRAK	vi
	TABLE OF CONTENTS	vii
	LIST OF TABLES	x
	LIST OF FIGURES	xi
	LIST OF SYMBOLS	xv
	LIST OF APPENDICES	xvi
1	INTRODUCTION	
1.1	Introduction	1
1.2	Background of Problem	4
1.3	Research Statement	5
1.4	Problem Statement	5
1.5	Objectives of Study	6
1.6	Scopes of Study	6
2	LITERATURE REVIEW	
2.1	Introduction	7
2.2	Research Trends for EDM	8
2.3	Electro Discharge Machining (EDM)	9
	2.3.1 Material Removal Theories	12
	2.3.1.1 Electro Mechanical Theory	12

	2.3.1.2 Thermo Mechanical Theory	12
	2.3.1.3 Thermo Electric Theory	13
	2.3.2 EDM Process Mechanism	13
	2.3.3 EDM Parameter	16
	2.3.3.1 Peak Current	18
	2.3.3.2 Discharge Voltage	18
	2.3.3.3 Pulse ON Time	19
	2.3.3.4 Pulse OFF Time	19
	2.3.4 Electrode	20
	2.3.5 Dielectric Fluid	22
2.4	EDM Surface Layer	24
2.5	Titanium Alloys	27
	2.5.1 Introduction	27
	2.5.2 Classification of Titanium Alloy	28
	2.5.2.1 Commercially Pure (CP) Titanium	28
	2.5.2.2 Alpha and Near-Alpha Alloys	29
	2.5.2.3 Alpha-beta Alloys	30
	2.5.2.4 Beta Alloys	30
	2.5.3 EDM of Titanium Alloys	33
	2.5.3.1 Machining Titanium Alloys with EDM	31
	2.5.3.2 Surface Integrity in EDM of Titanium Alloys	33
2.6	Design of Experiment (DOE)	34
	2.6.1 Two Level Factorial Design	35
3	RESEARCH DESIGN	
3.1	Introduction	36
3.2	Research Design Variables	36
	3.2.1 Machining Parameters	37
	3.2.1.1 Workpiece Material	37
	3.2.1.2 Electrode Material	39
	3.2.2 Two Level Factorial Design	39
	3.2.3 Response Parameters	43
	3.2.3.1 Recast Layer and Heat Affected Zone	43
	3.2.3.2 Surface Topography	43

3.2.3.3	Micro crack and Void	43
3.3	Experimental Machines and Analytical Equipments	44
4	RESULT AND DATA ANALYSIS	
4.1	Introduction	48
4.2	Experimental Results	48
4.2.1	EDM with POCO 3 and POCO C3	49
4.3	Recast Layer	53
4.3.1	Recast Layer with POCO 3	53
4.3.2	Recast Layer with POCO C3	59
4.3.3	Discussion on Recast Layer Between POCO 3 and POCO C3.	65
4.4	Heat Affected Zone (HAZ)	67
4.4.1	Heat Affected Zone with POCO 3	67
4.4.2	Heat Affected Zone with POCO C3	76
4.4.3	Discussion on Heat Affected Zone Between POCO 3 and POCO C3.	85
4.5	Surface Topography	87
4.5.1	Surface Topography with POCO 3	87
4.5.2	Surface Topography with POCO C3	92
4.5.3	Discussion on Surface Topography Between POCO 3 and POCO C3	96
4.6	Micro-crack and Void	99
4.6.1	Micro-crack and Void with POCO 3	100
4.6.2	Micro-crack and Void with POCO C3	101
4.6.3	Discussion on Micro-crack and Void Between POCO 3 and POCO C3.	103
5	CONCLUSION AND RECOMMENDATION	
5.1	Introduction	105
5.2	Conclusion	105
5.3	Recommendation	107
	REFERENCES	108
	Appendices A - E	111 - 142

LIST OF TABLES

TABLE NO.	TITLE	PAGE
2.1	Properties of Graphite and Copper Electrode	21
3.1	Machining Parameters	37
3.2	Chemical Properties of Ti-6Al-4V (wt.%)	38
3.3	Mechanical Properties of Ti-6Al-4V	38
3.4	Specification of Electrode Material	39
3.5	Factors and Levels for EDM with POCO 3 and POCO C3	40
3.6	Two-level full factorial experiment with four factors	40
4.1	Experimental plan for EDM with POCO 3 and POCO C3	50
4.2	Experimental Results for EDM with POCO 3	51
4.3	Experimental Results for EDM with POCO C3	52
4.4	ANOVA Table for Recast Layer for POCO 3	54
4.5	ANOVA Table for Recast Layer (RL) for POCO C3	60
4.6	Summary of Significant Factors (ARLT)	65
4.7	ANOVA Table for Heat Affected Zone (HAZ) for POCO 3	69
4.8	ANOVA Table for Heat Affected Zone (HAZ) for POCO C3	78
4.9	Summary of Significant Factors (Average HAZ)	86

LIST OF FIGURES

FIGURE NO.	TITLE	PAGE
2.1	Classification of Major EDM Research Area	8
2.2	Classification of EDM Process	9
2.3	Schematic of an Electro Discharge Machining (EDM)	10
2.4	The Lazarenko RC Circuit (McGeough, 1988)	11
2.5	Steps during EDM Cycle	14
2.6	Characteristic of Dielectric Fluid	23
2.7	Surface Layers formed by EDM Process	25
2.8	EDMed Surface layer for Ti6AL4V	26
3.1	Microstructure of Ti-6Al-4V (SEM Magnification 1000X)	38
3.2	Flowchart of the Specimens Inspection	42
3.3	Sodick AQ55L CNC EDM die sink	44
3.4	Grinder and Polisher	45
3.5	Optical Microscope	46
3.6	Scanning Electron Microscope (SEM)	46
3.7	X-Ray Diffraction (XRD) Machine	47
4.1	Normal Probability Plots of Residuals of RL for EDM with POCO 3	55
4.2	Residual vs Predicted Response of RL for EDM with POCO 3	55
4.3	Outlier T Plot of RL for EDM with POCO 3	56
4.4	Main Effect Plot of RL for EDM with POCO 3	57

4.5	Interaction between Servo Voltage (A) and Pulse ON (C) Plot of RL for EDM with POCO 3	57
4.6	Perturbation Plot of RL for EDM with POCO 3	58
4.7	Normal Probability Plots of Residuals of RL for EDM with POCO C3	61
4.8	Residual vs Predicted Response of RL for EDM with POCO C3	61
4.9	Outlier T Plot of RL for EDM with POCO C3	62
4.10	Pulse ON Time Effect Plot of RL for EDM with POCO C3	63
4.11	Pulse OFF Time Effect Plot of RL for EDM with POCO C3	63
4.12	Interaction between Servo Voltage (A) and Peak Current (B) Plot of RL for EDM with POCO C3	64
4.13	Perturbation Plot of RL for EDM with POCO C3 Electrode	65
4.14	Normal Probability Plots of Residuals of HAZ for EDM with POCO 3	70
4.15	Residual vs Predicted Response of HAZ for EDM with POCO 3	71
4.16	Outlier T Plot of HAZ for EDM with POCO 3	71
4.17	Interaction between Servo Voltage (A) and Peak Current (B) Plot of HAZ for EDM with POCO 3	73
4.18	Interaction between Servo Voltage (A) and Pulse ON (C) Plot of HAZ for EDM with POCO	73
4.19	Interaction between Servo Voltage (A) and Pulse OFF (D) Plot of HAZ for EDM with POCO 3	74
4.20	Interaction between Peak Current (B) and Pulse OFF (D) Plot of HAZ for EDM with POCO 3	74
4.21	Interaction between Pulse ON (C) and Pulse OFF (D) Plot of HAZ for EDM with POCO 3	75
4.22	Perturbation Plot of HAZ for EDM with POCO 3	76
4.23	Normal Probability Plots of Residuals of HAZ for EDM with POCO C3	79

4.24	Residual vs Predicted Response of HAZ for EDM with POCO C3	80
4.25	Outlier T Plot of HAZ for EDM with POCO C3	80
4.26	Interaction between Servo Voltage (A) and Peak Current (B) Plot of HAZ for EDM with POCO C3	82
4.27	Interaction between Servo Voltage (A) and Pulse ON (C) Plot of HAZ for EDM with POCO C3	82
4.28	Interaction between Servo Voltage (A) and Pulse OFF (D) Plot of HAZ for EDM with POCO C3	83
4.29	Interaction between Peak Current (B) and Pulse ON (C) Plot of HAZ for EDM with POCO C3	83
4.30	Interaction between Peak Current (B) and Pulse OFF (D) Plot of HAZ for EDM with POCO C3	84
4.31	Interaction between Pulse ON (C) and Pulse OFF (D) Plot of HAZ for EDM with POCO C3	84
4.32	Perturbation Plot of HAZ for EDM with POCO C3	85
4.33(a)	SEM Photographs show EDMed surface using POCO 3 ($SV=60V$, $I_p=20A$, $t_{ON}=150\mu s$, $t_{OFF}=150\mu s$)	88
4.33(b)	SEM Photographs show EDMed surface using POCO 3 ($SV=60V$, $I_p=20A$, $t_{ON}=150\mu s$, $t_{OFF}=150\mu s$)	89
4.34(a)	SEM Photographs show EDMed surface using POCO 3 ($SV=60V$, $I_p=20A$, $t_{ON}=150\mu s$, $t_{OFF}=50\mu s$)	89
4.34(b)	SEM Photographs show EDMed surface using POCO 3 ($SV=60V$, $I_p=20A$, $t_{ON}=150\mu s$, $t_{OFF}=50\mu s$)	90
4.35(a)	Spectrum of EDAX Analysis for Ti64 Surface after EDM with POCO 3	91
4.35(b)	EDAX Analysis for Ti64 Surface after EDM with POCO 3	91
4.36(a)	SEM Photographs show EDMed Surface using POCO C3 ($SV=120V$, $I_p=10A$, $t_{ON}=50\mu s$, $t_{OFF}=50\mu s$)	92
4.36(b)	SEM Photographs show EDMed Surface using POCO C3 ($SV=120V$, $I_p=10A$, $t_{ON}=50\mu s$, $t_{OFF}=50\mu s$)	93

4.37(a) SEM Photographs show EDMed Surface using POCO C3 ($SV=120V$, $I_p=20A$, $t_{ON}=150\mu s$, $t_{OFF}=150\mu s$)	93
4.37(b) SEM Photographs show EDMed Surface using POCO C3 ($SV=120V$, $I_p=20A$, $t_{ON}=150\mu s$, $t_{OFF}=150\mu s$)	94
4.38(a) Spectrum of EDAX Analysis for Ti64 Surface after EDM with POCO C3	95
4.38(b) EDAX Analysis for Ti64 Surface after EDM with POCO C3	95
4.39 X-ray Diffraction of Ti6Al4V Surface before EDM	98
4.40 X-ray Diffraction of Ti6Al4V after EDM with POCO 3	98
4.41 X-ray Diffraction of Ti6Al4V after EDM with POCO C3	99
4.42 Micro-crack on Specimen No. 6 with POCO 3	100
4.43 Micro-crack and Void on Specimen No. 16 with POCO 3	101
4.44 Micro-crack and Void on Specimen No. 16 with POCO C3	102
4.45 Micro-crack and Void on Specimen No. 12 with POCO C3	102

LIST OF SYMBOLS

Al	-	Aluminium
ANOVA	-	Analysis Of Variance
C	-	Carbon
EDAX	-	Energy Dispersive X-Ray Spectroscopy
EDM	-	Electro Discharge Machining
ARLT	-	Average Recast Layer Thickness
AWLT	-	Average White Layer Thickness
EWR	-	Electrode Wear Rate
HAZ	-	Heat Affected Zone
MRR	-	Material Removal Rate
SEM	-	Scanning Electron Microscopy
SR	-	Surface Roughness
ON	-	Pulse On Time (Pulse Duration)
OFF	-	Pulse Off Time (Pulse Interval)
IP	-	Peak Current
SV	-	Servo Voltage
Ti	-	Titanium
XRD	-	X-Ray Diffraction
θ	-	Angle
\varnothing	-	Diameter
μ	-	Micro
Ω	-	Ohm

LIST OF APPENDICES

APPENDIX	TITLE	PAGE
A	Electrodes for EDM (Mahajan, 1981)	107
B1	SEM of Recast Layer and Heat Affected Zone for POCO 3	108
B2	SEM of Recast Layer and Heat Affected Zone for POCO C3	116
C1	Experimental Results of EDM with POCO 3	123
C2	Experimental Results of EDM with POCO C3	124
D1	SEM of Surface Topography with POCO 3	125
D2	SEM of Surface Topography with POCO C3	130
E1	SEM of Micro crack and Void with POCO 3	135
E2	SEM of Micro crack and Void with POCO C3	137